



NICALLOY Fe-7

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCrFe-7

CLASSIFICATION:

ISO 14172

E Ni 6152 (NiCr30Fe9Nb)

KEY FEATURES:

- Basic type coating
- Ni-Cr-Fe type deposit
- Higher Cr content improves resistance to Stress corrosion Cracking
- Resistance to high temperature oxidation
- All Positional welding capability
- For overlay applications minimum three layers must be deposited

TYPICAL APPLICATIONS:

- Welding of alloys of Alloy 690 type
- Overlay welding in the nuclear industry
- Welding of steam generators in nuclear power plants
- Dissimilar Joining
- Joining and surfacing high alloyed 35/45CrNi
- High temperature cast materials


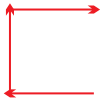
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Cr	Nb+Ta
0.025	2.3	0.7	8.0	63.5	29.6	1.35

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	40-60	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	60-80		
4.0 x 350	100-140		

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.